






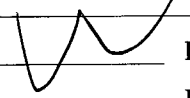


# Work Order ID 48670D

Friday, June 26, 2009 9:20:57 AM




Page 1


Item ID: D412-694-04 Accept  Setup Start   
Revision ID: C1 Stop   
Item Name: Door Assembly  
Start Date: 7/15/2009 Start Qty: 1.00  Cust Item ID:  
Required Date: 8/3/2009 Req'd Qty: 1.00  Customer:  
Reference:


Approvals: Process Plan:  Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start   
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop 

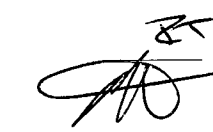
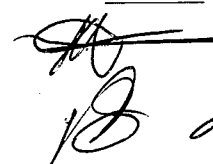
Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D412-694	Rev C1

100	DOCUMENT CONTROL	0.00							
									
DC	Memo	0.00							
Document Control	Issue red decal labels for D412-694-04.	CHG005							

110	COMPOSITE ASSEMBLY	0.00							
									
Small Fab	Memo	0.00							
Small Fab	D412-694-04 Drill Process 1- Drill pilot holes Ø(#30) using Dwg Tool D3140-303A for the doublers. Drill (2) holes in two places Ø3/16" (0.188) for the slot opening. Router slot using D3144-T11/-T12 as per Dwg D412-694 page 3. Note: Ensure slot is aligned								

120	QC5- Inspect part completeness to step on W/O	0.00							
									
QC	Memo	0.00							
Quality Control									

 09-10-03  
091003  
 091003

# Work Order ID 48670D



Page 2

Friday, June 26, 2009 9:20:57 AM

Item ID: D412-694-04

Accept



Setup Start



Revision ID: C1

Stop



Item Name: Door Assembly

Start Date: 7/15/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 8/3/2009 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

130



Small Fab

COMPOSITE ASSEMBLY

0.00

Memo

0.00

1- Install inserts as per Dwg D412-694 page 3 & 5 (section AA-AA) and page 4 (view MM-MM). □ 2- Sand flush excess Hysol around the insert on both doors.

EA 934 A/B m110970  
m112099

80 09-10-07

091003

140



QC

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

Inspect that inserts are flush with the surface.

1

09-10-07

150



Small Fab

COMPOSITE ASSEMBLY

0.00

Memo

0.00

1. Apply primer filler and reducer around the inserts on both doors. □ A/R  
11045 Primer Filler Batch: M112704 □ A/R  
12375S Reducer Batch: M112704

80 09-10-07

# Work Order ID 48670D



Page 3

Friday, June 26, 2009 9:20:57 AM

Item ID:	D412-694-04	Accept		Setup	Start	
Revision ID:	C1				Stop	
Item Name:	Door Assembly					
Start Date:	7/15/2009	Start Qty:	1.00		Cust Item ID:	
Required Date:	8/3/2009	Req'd Qty:	1.00		Customer:	
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 ✓ QC Quality Control	QC5- Inspect part completeness to step on W/O  Memo	0.00  0.00				1			05-16-07
170 ✓ Small Fab Small Fab	COMPOSITE ASSEMBLY  Memo D412-694-04 Assembly Process □ 1- Install top/bottom of the door, D3112-1 Guard, D3130-1 Clevis Base and D3131-1 Stop (top only) as per Dwg D412-694 page 5 (section AA-AA & FF-FF). □ 2- Install D3111-041 Plate Assembly. If needed, insta	0.00  0.00							091007 09-10-07
180 ✓ QC Quality Control	QC5- Inspect part completeness to step on W/O  Memo Install door on mock up helicopter to insure proper fit and function.	0.00  0.00				1			05-16-07

**Work Order ID 48670D**

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Friday, June 26, 2009 9:20:57 AM

Item ID: D412-694-04

Accept

Setup Start

Revision ID: C1

Stop

Item Name: Door Assembly

Start Date: 7/15/2009 Start Qty: 1.00

Cust Item ID:

Required Date: 8/3/2009 Req'd Qty: 1.00

Customer:

Reference:

Run Start

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

190



Small Fab

Small Fab

Small Fab

Memo

(Put red label inside before putting the cover D3119-042/or Vip trim)

0.00

0.00

091007

200



Packaging

Packaging

Identify as per dwg &amp; Stock Location: \_\_\_\_\_

Memo

0.00

0.00

48670

210



QC

Quality Control

QC21- Final Inspection - Work Order Release

Memo

0.00

0.00

09/10/07

09/10/07

# Picklist Print

Friday, June 26, 2009 9:20:56 AM

Page 1

Work Order ID: 48670D

Parent Item: D412-694-04RevC1

Parent Item Name: Door Assembly










Comments:

Start Date: 7/15/2009

Required Date: 8/3/2009

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
✓ NAS43DD3-40 		Purchased	No	A117		110	Each	0.0000	2.0000			
Spacer												
✓ 80-005-2-8 		Purchased	No			170	Each	0.0000	21.0000			
Insert												
✓ ALS4-632-80 		Purchased	No			170	Each	0.0000	10.0000			
Insert												
✓ AN525-10R7 		Purchased	No			170	Each	0.0000	4.0000			
Screw												
✓ AN960JD10 		Purchased	No			170	Each	0.0000	8.0000			
Washer												
✓ AN960JD10L 		Purchased	No			170	Each	0.0000	13.0000			
Washer												
✓ AN960JD10LL 		Purchased	No			170	Each	0.0000	29.0000			
Washer												
✓ AN960JD6L 		Purchased	No			170	Each	0.0000	4.0000			
Washer												
✓ AN960JD8 		Purchased	No			170	Each	0.0000	2.0000			
Washer												

M110153 SC

M19443 SC

M 17841 SC

M112314 SC

M112369 SC

M109632 SC

M19600 SC

M5519 SC

M11578 SC

9/9/17 @

# Picklist Print

Page 2

Friday, June 26, 2009 9:20:56 AM

Work Order ID: 48670D

Parent Item: D412-694-04RevC1

Parent Item Name: Door Assembly










Comments:

Start Date: 7/15/2009

Required Date: 8/3/2009

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
✓ AN960JD8L 		Purchased	No			170	Each	0.0000	2.0000			
Washer BSP45 		Purchased	No			170	Each	0.0000	34.0000			
Commercial Rivet BSP46 		Purchased	No			170	Each	0.0000	12.0000			
Commercial rivet D3110-1RevC 		Manufactured	No			170	Each	0.0000	1.0000			
Escutcheon D3110-3RevC 		Manufactured	No			170	Each	0.0000	1.0000			
Handle D3111-041RevB 		Manufactured	No			170	Each	0.0000	1.0000			
Plate Assembly D3112-1RevB 		Manufactured	No			170	Each	0.0000	2.0000			
Guide D3113-1RevB 		Manufactured	No			170	Each	0.0000	1.0000			
Spring D3114-1RevB 		Manufactured	No			170	Each	0.0000	1.0000			
Pivot												

M 6956 SP

M107296 SP

M101237 SP

31757 SP

50041 SP

M10536-17 SP

81644 SP

36725 SP

36726 SP

9/9/17 Cx

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# Picklist Print

Page 3

Friday, June 26, 2009 9:20:56 AM

Work Order ID: 48670D

Parent Item: D412-694-04RevC1

Parent Item Name: Door Assembly










Comments:

Start Date: 7/15/2009

Required Date: 8/3/2009

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
✓ D3116-11RevA 		Manufactured	No			170	Each	0.0000	1.5000	27241		sc
Seal												
✓ D3116-5RevA 		Manufactured	No			170	f	0.0000	5.6700	27208		sc
Seal												
✓ D3119-042RevB 		Manufactured	No			170	Each	0.0000	1.0000	1327725		sc
Cover Assembly												
✓ D3120-2RevB 		Manufactured	No			170	Each	0.0000	1.0000	50344		sc
Cover												
✓ D3120-4RevB 		Manufactured	No			170	Each	0.0000	1.0000	1350337		sc
Cover												
✓ D3125-1RevC 		Manufactured	No			170	Each	0.0000	1.0000	M1053617		sc (P10)→
Lever												
✓ D3125-3RevC 		Manufactured	No			170	Each	0.0000	1.0000	M1053617		sc
Lever												
✓ D3125-5RevC 		Manufactured	No			170	Each	0.0000	1.0000	M1053617		sc
Lever												
✓ D3125-7RevC 		Manufactured	No			170	Each	0.0000	1.0000	M1053617		sc
Lever												

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Work Order ID: 48670D

Parent Item: D412-694-04RevC1

Parent Item Name: Door Assembly



















Comments:

Start Date: 7/15/2009

Required Date: 8/3/2009

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
✓ D3129-1RevB  Lever		Manufactured	No			170	Each	0.0000	2.0000 	M1053617		sl
✓ D3130-1RevB  Clevis Base		Manufactured	No			170	Each	0.0000	2.0000 	M1053617		sl
✓ D3131-1RevB  Stop		Manufactured	No			170	Each	0.0000	1.0000 	M1053617		sl
✓ D3134-1RevE  Rod		Manufactured	No			170	Each	0.0000	1.0000 	27388		sl
✓ D3134-4RevE  Rod		Manufactured	No			170	Each	0.0000	1.0000 	18376 u <del>29129</del>		sl
✓ D3140-08RevF  Door		Manufactured	No			170	Each	0.0000	1.0000 	48670D		u
✓ D3143-1RevB  Clevis		Manufactured	No			170	Each	0.0000	1.0000 	M1053617		sl
✓ D3143-3RevB  Clevis		Manufactured	No			170	Each	0.0000	3.0000 	M1053617		sl
✓ D3144-117RevC  Doubler		Manufactured	No			170	Each	0.0000	1.0000 	B22022		sl

9/9/17 RSO

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Work Order ID: 48670D



Parent Item: D412-694-04RevC1



Parent Item Name: Door Assembly

Start Date: 7/15/2009

Required Date: 8/3/2009

Start Qty: 1.00

Required Qty: 1.00

Comments:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
✓ D3144-119RevC 		Manufactured	No			170	Each	0.0000	1.0000			
Doubler										22023		sc
✓ D3144-121RevC 		Manufactured	No			170	Each	0.0000	1.0000			
Doubler										B22024		sc
✓ D3145-2RevB 		Manufactured	No			170	Each	0.0000	1.0000			
Bracket										B31734		sc
✓ D3146-2RevB 		Manufactured	No			170	Each	0.0000	1.0000			
Bracket										B46928		sc
✓ D3147-1RevC 		Manufactured	No			170	Each	0.0000	2.0000			
Pin										① 41-41616 ① 41930		sc
✓ D3149-1RevB 		Manufactured	No			170	Each	0.0000	2.0000			
Striker Plate										M10536-17		sc
✓ D3150-1RevB 		Manufactured	No			170	Each	0.0000	2.0000			
Guide										M10536-17		sc
✓ D3154-1RevB 		Manufactured	No			170	Each	0.0000	1.0000			
Key										M10536-17		sc
✓ D3157-1RevB 		Manufactured	No			170	Each	0.0000	2.0000			
Spacer										9/9/17 (K)		

(P10)  
→

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Work Order ID: 48670D

Parent Item: D412-694-04RevC1

Parent Item Name: Door Assembly

Comments:

Start Date: 7/15/2009

Required Date: 8/3/2009

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
✓ D3159-041RevC Bracket Assembly		Manufactured	No			170	Each	0.0000	3.0000			SP
✓ D3159-044RevC Bracket Assembly		Manufactured	No			170	Each	0.0000	1.0000			SP
✓ FW10-032 Washer		Purchased	No			170	Each	0.0000	16.0000			SP
✓ FW4-032 Washer		Purchased	No			170	Each	0.0000	6.0000			SP
✓ M7885/3-4-4 Rivets		Purchased	No			170	Each	0.0000	2.0000			SP
✓ M7885/3-4-5 Rivet		Purchased	No			170	Each	0.0000	1.0000			SP
✓ MS20392-1C11 Pin		Purchased	No			170	Each	0.0000	2.0000			SP
✓ MS20392-2C11 Pin		Purchased	No			170	Each	0.0000	2.0000			SP
✓ MS20392-2C15 Pin		Purchased	No			170	Each	0.0000	7.0000			SP

18641 SP

M1053617 SP

M19249 SP

~~M104625~~ M11822 SP

~~M79099~~ M104625 SP

M106167 SP

M18822 SP

M14149 SP

M101340 SP

7/9/17 @

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# Picklist Print

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Friday, June 26, 2009 9:20:56 AM

Work Order ID: 48670D

Parent Item: D412-694-04RevC1

Parent Item Name: Door Assembly

Comments:

Start Date: 7/15/2009

Required Date: 8/3/2009

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
✓ MS21042L06 Nut		Purchased	No			170	Each	0.0000	2.0000			scf
✓ MS21042L3 Nut		Purchased	No			170	Each	0.0000	7.0000			scf
✓ MS24665-151 Cotter Pin		Purchased	No			170	Each	0.0000	11.0000			scf
✓ MS24694-C4 SCREW		Purchased	No			170	Each	0.0000	2.0000			scf
✓ MS24694-S53 SCREW		Purchased	No			170	Each	0.0000	2.0000			scf
✓ MS24694-S56 SCREW		Purchased	No			170	Each	0.0000	4.0000			scf
✓ MS24694-S60 Screw		Purchased	No			170	Each	0.0000	4.0000			scf
✓ MS25281-R6 Clamp		Purchased	No			170	Each	0.0000	2.0000			scf
✓ MS27039-1-06 Screw		Purchased	No			170	Each	0.0000	12.0000			scf

M112243 scf

M111274 scf

14526 scf

M15924 scf

M15788 scf

M104407 scf

② M104407 M1176650

M19098 scf

M106815 scf

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# Picklist Print

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Work Order ID: 48670D

Parent Item: D412-694-04RevC1

Parent Item Name: Door Assembly








Start Date: 7/15/2009

Required Date: 8/3/2009

Start Qty: 1.00

Required Qty: 1.00

Comments:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
MS27039-1-08 		Purchased	No			170	Each	0.0000	6.0000	 M110552		SD
Screw												
MS35206-231 		Purchased	No			170	Each	0.0000	2.0000	 M11735		SD
Screw												
MS35650-305T 		Purchased	No			170	Each	0.0000	4.0000	 M11786		SD
Nut												
MS51859-7 		Purchased	No			170	Each	0.0000	3.0000	 M11193		SD
Washer												
NAS1169-10L 		Purchased	No			170	Each	0.0000	4.0000	 M11753		SD
Washer												
NAS388-6-8P 		Purchased	No			170	Each	0.0000	15.0000	 M111439		SD
Screw												
NAS391B6P 		Purchased	No			170	Each	0.0000	16.0000	 M110221		SD
Washer												

①  
-1 M112768

①④

9/9/17 @SD

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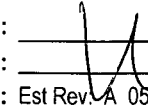
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②

Date: Monday, 22/06/2009 11:54:52 AM  
 User: Linda Lacelle

## Process Sheet

<b>Customer</b> :	CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> :	DOOR ASSEMBLY
<b>Job Number</b> :	48670D		
<b>Estimate Number</b> :	12357		
<b>P.O. Number</b> :		<b>Part Number</b> :	D41269404
<b>This Issue</b> :	22/06/2009	<b>S.O. No.</b> :	
<b>Prsht Rev.</b> :	NC	<b>Drawing Number</b> :	D412-694
<b>First Issue</b> :	22/06/2009	<b>Project Number</b> :	N/A
<b>Previous Run</b> :	39169D	<b>Drawing Revision</b> :	C1
<b>Written By</b> :		<b>Material</b> :	
<b>Checked &amp; Approved By</b> :		<b>Due Date</b> :	10/09/2009
<b>Comment</b> :	Est Rev: A 05.12.09 New Issue	<b>Qty:</b>	1 Um: Each
	Est Rev: B 06.04.18 New dwg rev. ecn781		
	Est Rev: C 06.07.10 Revised per B24659		

## Additional Product

Job Number:



<b>Seq. #:</b>	<b>Machine Or Operation:</b>	<b>Description :</b>
----------------	------------------------------	----------------------

1.0 DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Issue red decal labels for D412-694-04. CHG005

2.0 PG

PURCHASING



Comment: PURCHASING

ISSUE P.O. 9004 1 X D3140-08 REV.F  
DELASTEK

C209/06/23 ①

3.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

RECEIVE AND INSPECT FOR TRANSIT DAMAGE  
ENSURE MATERIAL CERT AND PROCESS SHEET ATTACHED

4.0

QC6

DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

5.0

D314008

Door



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Door Kit

Batch

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Monday, 22/06/2009 11:54:52 AM  
User: Linda Lacelle

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DOOR ASSEMBLY

Job Number: 48670D

Part Number: D41269404

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

COMPOSITE ASSY

COMPOSITE ASSEMBLY



Comment: COMPOSITE ASSEMBLY

D412-694-04 Drill Process

1- Drill pilot holes Ø(#30) using Dwg Tool D3140-303A for the doublers. Drill (2) holes in two places Ø3/16" (0.188) for the slot opening. Router slot using D3144-T11/-T12 as per Dwg D412-694 page 3. Note: Ensure slot is aligned with mark for reference.

2- Drill Pilot holes Ø(#30) using drill Jig D3120-4T1 for bottom cover. Use unibit to open holes to Ø37/64" (0.578) for inserts as per Dwg D412-694 page 3.

3- Drill Pilot holes Ø(#30) using drill Jig DT8703-10 for hinges, top cover and D3131-1 spring. Use unibit to open holes to Ø37/64" (0.578) for inserts as per Dwg D412-694 page 3 & 4 (view MM-MM).

4- Drill Pilot holes Ø(#1/8") for clevis base and stop at top of the door using drill Jig DT8703-11. Open (1) hole Ø(#10) 0.193 for clevis base and (2) holes Ø(#19) 0.166 for stop as per Dwg D412-694 page 5 (section FF-FF.)

5- Drill Pilot hole Ø(#1/8") for clevis base at bottom of the door using drill Jig DT8703-12. Open hole Ø(#10) 0.193 for clevis base as per Dwg D412-694 page 5 (section FF-FF).

6- Ensure 17 1/16" from opposite edge of the door for Ø5/8" hole is in proper location top and bottom.

7- Drill through only (1) hole Ø(5/8") and pilot drill (2) holes Ø(#30) for insert top and bottom. Open (2) holes to 37/64" (0.578) for clevis inserts as per Dwg D412-694 page 5 (section AA-AA).

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

8.0

8000528

Insert



Comment: Qty.: 21.0000 Each(s)/Unit Total : 21.0000 Each(s)

Insert

Batch

A/R Hysol EA934NA

Expiry Date:

9.0

COMPOSITE ASSY

COMPOSITE ASSEMBLY



Comment: COMPOSITE ASSEMBLY

1- Install inserts as per Dwg D412-694 page 3 & 5 (section AA-AA) and page 4 (view MM-MM).

2- Sand flush excess Hysol around the insert on both doors.

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: DH12-694-04 PAR #: \_\_\_\_\_ Fault Category: Prod. Small Fals NCR: Yes No DQA: \_\_\_\_\_ Date: 09.10.14  
 Resolution: Scrap Disposition: Scrap QA: N/C Closed: \_\_\_\_\_ Date: 09.10.14

NCR: <u>48670D</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
<u>09/10/07</u>	<u>170</u>	<u>One part scrap</u> <u>D3125-1</u> <u>Part had to be modified to</u> <u>accommodate the door thickness; was</u> <u>ground down too much.</u> <u>R.C. process</u>	<u>[Signature]</u> <u>09/10/07</u>	<u>Replace with</u> <u>D3125-1</u> <u><del>10536-17</del></u> <u>M# 10536-17</u>	<u>[Signature]</u> <u>09.10.07</u>	<u>[Signature]</u> <u>09.10.07</u>	<u>[Signature]</u> <u>09.10.07</u>	<u>[Signature]</u> <u>09.10.07</u>

NOTE: Date & initial all entries



Date: Monday, 22/06/2009 11:54:52 AM  
User: Linda Lacelle

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DOOR ASSEMBLY

Job Number: 48670D

Part Number: D41269404

Job Number:



Seq. #:

Machine Or Operation:

Description :

10.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Inspect that inserts are flush with the surface.

11.0

COMPOSITE ASSY

COMPOSITE ASSEMBLY



Comment: COMPOSITE ASSEMBLY

1. Apply primer filler and reducer around the inserts on both doors.

A/R 11045

Primer Filler

Batch: \_\_\_\_\_

A/R 12375S

Reducer

Batch: \_\_\_\_\_

12.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

13.0

D31101

Escutcheon



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Escutcheon

Batch: \_\_\_\_\_

14.0

D31103

Handle



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Handle

Batch: \_\_\_\_\_

15.0

D3111041

Plate Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Plate Assembly

Batch: \_\_\_\_\_

16.0

D31121

Guide



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Guide

Batch: \_\_\_\_\_

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval. QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Monday, 22/06/2009 11:54:52 AM  
User: Linda Lacelle

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DOOR ASSEMBLY

Job Number: 48670D

Part Number: D41269404

Job Number:



Seq. #:

Machine Or Operation:

Description :

17.0



D31131

Spring



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Spring

Batch

18.0



D31141

Pivot



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pivot

Batch

19.0



D31165

Seal



Comment: Qty.: 5.6700 f(s)/Unit Total : 5.6700 f(s)

Seal 110-031-4

Batch

20.0



D311611

Seal



Comment: Qty.: 1.5000 f(s)/Unit Total : 1.5000 f(s)

SEAL

Batch

21.0



D3119042

Cover Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Cover Assembly

Batch

22.0



D31202

Cover



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Cover, Flat Pattern

Batch

23.0



D31204

Cover



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Cover

Batch

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Monday, 22/06/2009 11:54:53 AM  
User: Linda Lacelle

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DOOR ASSEMBLY

Job Number: 48670D

Part Number: D41269404

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

24.0 ✓	D31251	Lever
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)  
Lever  
Batch \_\_\_\_\_

25.0 ✓	D31253	Lever
--------	--------	-------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)  
Lever  
Batch \_\_\_\_\_

26.0 ✓	D31255	Lever
--------	--------	-------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)  
Lever  
Batch \_\_\_\_\_

27.0 ✓	D31257	Lever
--------	--------	-------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)  
Lever  
Batch \_\_\_\_\_

28.0 ✓	D31291	Lever
--------	--------	-------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)  
Lever  
Batch \_\_\_\_\_

29.0 ✓	D31301	Clevis Base
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)  
Clevis Base  
Batch \_\_\_\_\_

30.0 ✓	D31311	Stop
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)  
Stop  
Batch \_\_\_\_\_

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Monday, 22/06/2009 11:54:53 AM  
User: Linda Lacelle

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DOOR ASSEMBLY

Job Number: 48670D

Part Number: D41269404

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

31.0 ✓	D31341	Rod
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Rod  
Batch

32.0 ✓	D31344	Rod
--------	--------	-----



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Rod  
Batch

33.0 ✓	D31431	Clevis
--------	--------	--------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Clevis  
Batch

34.0 ✓	D31433	Clevis
--------	--------	--------



Comment: Qty.: 3.0000 Each(s)/Unit Total : 3.0000 Each(s)

Clevis

35.0 ✓	D3144117	Doubler
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Doubler  
Batch

36.0 ✓	D3144119	Doubler
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Doubler  
Batch

37.0 ✓	D3144121	Doubler
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Doubler  
Batch

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



Date: Monday, 22/06/2009 11:54:53 AM  
User: Linda Lacelle

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DOOR ASSEMBLY

Job Number: 48670D

Part Number: D41269404

Job Number:



Seq. #:

Machine Or Operation:

Description :

38.0

✓ D31452

Bracket



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Bracket

Batch \_\_\_\_\_

39.0

✓ D31462

Bracket



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Hinge Bracket

Batch \_\_\_\_\_

40.0

✓ D31471

Pin



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pin

Batch \_\_\_\_\_

41.0

✓ D31491

Striker Plate



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Striker Plate

Batch \_\_\_\_\_

42.0

✓ D31501

Guide



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Guide

Batch \_\_\_\_\_

43.0

✓ D31541

Key



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Key

Batch \_\_\_\_\_

44.0

✓ D31571

Spacer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Spacer

Batch \_\_\_\_\_

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval. QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Monday, 22/06/2009 11:54:53 AM  
User: Linda Lacelle

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DOOR ASSEMBLY

Job Number: 48670D

Part Number: D41269404

Job Number:



Seq. #:

Machine Or Operation:

Description :

45.0

✓ D3159041

Bracket Assembly



Comment: Qty.: 3.0000 Each(s)/Unit Total : 3.0000 Each(s)

Bracket Assembly

Batch

46.0

✓ D3159044

Bracket Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Bracket Assembly

Batch

47.0

✓ AN52510R7

Screw



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Screw

Batch

48.0

✓ AN960JD6L

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Washer

Batch

49.0

✓ AN960JD8

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Washer

50.0

✓ AN960JD8L

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Washer

Batch

51.0

✓ AN960JD10

Washer



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

Washer

Batch

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Monday, 22/06/2009 11:54:53 AM  
User: Linda Lacelle

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DOOR ASSEMBLY

Job Number: 48670D

Part Number: D41269404

Job Number:



Seq. #:	Machine Or Operation:	Description :
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52.0	✓ AN960JD10L	Washer
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Comment: Qty.: 13.0000 Each(s)/Unit Total : 13.0000 Each(s)

Washer

Batch

53.0	✓ AN960JD10LL	Washer
------	---------------	--------



Comment: Qty.: 29.0000 Each(s)/Unit Total : 29.0000 Each(s)

Washer

Batch

54.0	✓ ALS463280	Insert
------	-------------	--------



Comment: Qty.: 10.0000 Each(s)/Unit Total : 10.0000 Each(s)

Insert

Batch

55.0	✓ BSP45	Commercial Rivet
------	---------	------------------



Comment: Qty.: 34.0000 Each(s)/Unit Total : 34.0000 Each(s)

Commercial Rivet

Batch

56.0	✓ BSP46	Commercial rivet
------	---------	------------------



Comment: Qty.: 12.0000 Each(s)/Unit Total : 12.0000 Each(s)

Commercial rivet

Batch

57.0	✓ FW4032	Washer
------	----------	--------



Comment: Qty.: 6.0000 Each(s)/Unit Total : 6.0000 Each(s)

Washer

Batch

58.0	✓ FW10032	Washer
------	-----------	--------



Comment: Qty.: 16.0000 Each(s)/Unit Total : 16.0000 Each(s)

Washer

Batch

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Monday, 22/06/2009 11:54:53 AM  
User: Linda Lacelle

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DOOR ASSEMBLY

Job Number: 48670D

Part Number: D41269404

Job Number:



Seq. #:

Machine Or Operation:

Description :

59.0



M7885344

Rivets



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Rivets

Batch

60.0



M7885345

Rivet



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Rivet

Batch

61.0



MS203921C11

Pin



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pin

Batch

62.0



MS203922C11

Pin



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pin

Batch

63.0



MS203922C15

Pin



Comment: Qty.: 7.0000 Each(s)/Unit Total : 7.0000 Each(s)

Pin

Batch

64.0



MS21042L3

Nut



Comment: Qty.: 7.0000 Each(s)/Unit Total : 7.0000 Each(s)

Nut

Batch

65.0



MS21042L06

Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Nut

Batch

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



Date: Monday, 22/06/2009 11:54:53 AM  
User: Linda Lacelle

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DOOR ASSEMBLY

Job Number: 48670D

Part Number: D41269404

Job Number:



Seq. #:

Machine Or Operation:

Description :

66.0



MS24665151

Cotter Pin



Comment: Qty.: 11.0000 Each(s)/Unit Total : 11.0000 Each(s)

Cotter Pin

Batch

67.0



MS24694C4

SCREW



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

SCREW

Batch

68.0



MS24694S53

SCREW



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

SCREW

Batch

69.0



MS24694S56

SCREW



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

SCREW

Batch

70.0



MS24694S60

Screw



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Screw

Batch

71.0



MS25281R6

Clamp



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Clamp

Batch

72.0



MS27039106

Screw



Comment: Qty.: 12.0000 Each(s)/Unit Total : 12.0000 Each(s)

Screw

Batch

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Monday, 22/06/2009 11:54:53 AM  
User: Linda Lacelle

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DOOR ASSEMBLY

Job Number: 48670D

Part Number: D41269404

Job Number:



Seq. #:

Machine Or Operation:

Description :

73.0



MS27039108

Screw



Comment: Qty.: 6.0000 Each(s)/Unit Total : 6.0000 Each(s)

Screw

Batch

74.0



MS35206231

Screw



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Screw

Batch

75.0



MS35650305T

Nut



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Nut

Batch

76.0



MS518597

Washer



Comment: Qty.: 3.0000 Each(s)/Unit Total : 3.0000 Each(s)

Washer

Batch

77.0



NAS116910L

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Washer

Batch

78.0



NAS38868P

Screw



Comment: Qty.: 15.0000 Each(s)/Unit Total : 15.0000 Each(s)

Screw

Batch

79.0



NAS391B6P

Washer



Comment: Qty.: 16.0000 Each(s)/Unit Total : 16.0000 Each(s)

Washer

Batch

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Monday, 22/06/2009 11:54:53 AM  
User: Linda Lacelle

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DOOR ASSEMBLY

Job Number: 48670D

Part Number: D41269404

Job Number:



Seq. #:

Machine Or Operation:

Description :

80.0

NAS43DD340

Spacer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Spacer

Batch

81.0

COMPOSITE ASSY

COMPOSITE ASSEMBLY



Comment: COMPOSITE ASSEMBLY

D412-694-04 Assembly Process

1- Install top/bottom of the door, D3112-1 Guard, D3130-1 Clevis Base and D3131-1 Stop (top only) as per Dwg D412-694 page 5 (section AA-AA & FF-FF).

2- Install D3111-041 Plate Assembly. If needed, install temporary D3110-3 Handle as per Dwg D412-694 page 5 (view W and section BB-BB).

Note: Adjust D3111-041 high with washer as required. Check that the D3154-1 key doesn't touch the base of the door.

3- Assemble Rod as per Dwg D412-694 page 5 (view W)

4- Assemble D3147-1 Pin to the lever as per Dwg D412-694 page 5 (section AA-AA & FF-FF).

5- Connect Rods and D3111-041 Plate Assembly as per Dwg D412-694 page 5 (view W).

6- Install D3111-041 and mechanism in place. Use D3110-3 Handle to make lock and mechanism of the rod work properly. Mark the center NAS1169-10L washer into the door and drill (#10) Ø0.193". C'sink Ø0.385 x 100° from far side of the door. Ensure D3111-041 is level with inside door surface as per Dwg D412-694 page 5 (view W).

7- Install (1) D3159-041 bracket assembly to side of the window. Transfer hole from the door to D3159-041 bracket. Drill Ø(#30) C'sink for the rivet (note: use 1" pitch holes) as per Dwg D412-694 page 5 (view W) and (section LL-LL).

8- Drill (#19), C'sink Ø0.332 x 100°. Install MS25281-R6 Clamp as per Dwg D412-694 page 5 (view W). Ensure Rod moves freely when installing clamps.

9- Install (1) D3159-044 bracket assembly. Transfer (2) holes from the door to the bracket. Install (1) M7885/3-4-5 rivet and install the second rivet with the doubler.

Note: Layout properly as per Dwg D412-694 page 5 (view W). Note: Second hole will be done with doubler and seal.

10- Drill (4) (#10) Ø0.193" holes from D3150-1 guide by laying out doublers with temporary seal segment with strike plate. Check location of strike plate by laying out small and large door together.

Note: Position strike plate when big door is in locked position.

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Monday, 22/06/2009 11:54:53 AM  
User: Linda Lacelle

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DOOR ASSEMBLY

Job Number: 48670D

Part Number: D41269404

Job Number:



Seq. #:

Machine Or Operation:

Description :

11- Open (#30) pilot hole to Ø"G" (0.261) in the door for ALS4-632-80 insert. Install insert as per Dwg D412-694 page 3.

12- Install Doublers and D3159-041 bracket. Cut slot openings from the door to D3116-5-0680 Seal as per Dwg D412-694 page 3 (section JJ-JJ)

13- Install D3150-1 Guide top/bottom as per Dwg D412-694 page 5 (view DD & CC).  
Note: Install D3128-1 shim as required.

14- Install Hinge Bracket and D3113-1 Spring as per Dwg D412-694 page 3 & 4 (view MM-MM).

15- Install top/bottom Covers. Attach D3116-11-0180 Seal as per Dwg D412-694 page 3  
A/R RTV732 Clear Batch: \_\_\_\_\_ Expiry: \_\_\_\_\_

FOR D412-694-011 ONLY

16- Drill Pilot holes Ø(#1/8") for D3119-042 cover using drilling Jig D3119-042T1/T2 as per Dwg D412-694 page 3. Trim D3119-042 Cover Assembly and transfer Ø(#30) holes using hole finder tool from the door to the cover. Open holes to Ø5/32" (0.156).

17- Install D3119-042 Cover and Assemble Handle as per Dwg D412-694 page 3 & 5 (section BB-BB). Align properly.

82.0

✓ QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Install door on mock up helicopter to insure proper fit and function.

83.0

✓ SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

(Put red label inside before putting the cover D3119-042/or Vip trim)

84.0

✓ PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

85.0

✓ QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval. QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



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CHECKED JH	APPROVED #	DRAWING NO. D3140	REV. F SHEET 1 OF 7
DATE 06.10.06		TITLE DOOR	SCALE NTS
A	02.04.18	NEW ISSUE	
B	03.01.23	REMOVE -65/-81/-83; ADD -301/-303	
C	04.11.08	CHANGE DELASTEK SPEC. TEC-77; ADD PART MARKING; ADD NOTES 11, 12, 13; CHANGE ANGLE -95/-97/-98 TO 106°	
D	05.11.23	ADD -103/-104/-105/-106; REMOVE -67	
E	06.06.09	1.75 WAS 1.88, 4.75 WAS 4.13 ON -08/-07, 1.00 WAS 1.20 ON -09/-10	
F	06.10.06	ADD NOTE 14; CORRECT PART TITLE, NOW D3140-09/-92/-104 SHOWN D3140-10/-91/-103 OPPOSITE	

RELEASED  
06.11.13 #

QTY -05	QTY -06	QTY -07	QTY -08	QTY -09	QTY -10	PART NUMBER	DESCRIPTION
X						D3140-05	DOOR
	X					D3140-06	DOOR
		X				D3140-07	DOOR
			X			D3140-08	DOOR
		1		X		D3140-09	DOUBLER ASSEMBLY
			1		X	D3140-10	DOUBLER ASSEMBLY
3	3					D3140-57	PAD
1	1					D3140-59	PAD
2	2					D3140-61	PAD
2	2					D3140-63	PAD
		1	1			D3140-69	PAD
		1	1			D3140-71	PAD
		1	1			D3140-73	PAD
		1	1			D3140-75	PAD
		1	1			D3140-77	PAD
		1	1			D3140-79	PAD
				1	1	D3140-85	ANGLE
1	1					D3140-87	DOUBLER
				1	1	D3140-89	DOUBLER
		1				D3140-91	DOUBLER
			1			D3140-92	DOUBLER
3	3					D3140-95	DOUBLER
1						D3140-97	DOUBLER
	1					D3140-98	DOUBLER
		1	1			D3140-99	DOUBLER
		2	2			D3140-101	DOUBLER
		1				D3140-103	DOUBLER
			1			D3140-104	DOUBLER
		1				D3140-105	DOUBLER
			1			D3140-106	DOUBLER
1	1					D3140-241	DOUBLER
1		1				D3140-301	DOUBLER
	1		1			D3140-303	DOUBLER
				5	5	MS20426AD3-4	RIVET



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CHECKED Jh	APPROVED #	DRAWING NO. D3140	REV. F SHEET 2 OF 7
DATE 06.10.06		TITLE DOOR	SCALE NTS

1

COMPOSITE LAYUP & BONDING I.A.W. DELASTEK PROCESS SPEC. TEC-77  
MATERIAL STORAGE & HANDLING TO BE I.A.W. DART QSI 006  
MAIN LAYUP USES FIBERCOTE E-761/7781 EPOXY FIBERGLASS.  
FILL WITH EPOCAST 87269 OR MAGNOBOND 77 A & B AND MA560 FOAM/ NB-51/30 FOAM

2

FINISH: DUPONT HIGHBUILD GREY PRIMER 1144-S

3

MAKE PARTS IN ACCORDANCE WITH THE FOLLOWING TOOLS/MOLDS:

PART	TOOL
D3140-05	B30-23000-01T
D3140-06	B30-23000-02T
D3140-07	B30-23000-03T
D3140-08	B30-23000-04T
D3140-57	B30-23000-57T
D3140-61	B30-23000-61T
D3140-63	B30-23000-63T
D3140-69	B30-23000-69T
D3140-71	B30-23000-71T
D3140-73	B30-23000-73T
D3140-75	B30-23000-75T
D3140-77	B30-23000-77T
D3140-79	B30-23000-79T
D3140-89	D3140-89T1
D3140-301	D3140-301T1
D3140-303	D3140-303T1

RELEASED

06.11.13

4

MATERIAL: 2024-T3 (QQ-A-250/4) 0.032 THICK (M2024T3S.032)  
FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1

5

MATERIAL: 2024-T3 (QQ-A-250/4) 0.020 THICK (M2024T3S.020)  
FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1

6

MATERIAL: 5052-H32/H34 (QQ-A-250/8) 0.040 THICK (M5052H32S.040)  
FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1

7

MATERIAL: POLIMEX TR75 1" THICK 4.5 LB KLEGECELL

8

ALL DIMENSIONS IN INCHES

9

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

10

MATERIAL: 6061-T6 (QQ-A-250/11) 0.063 THICK (M6061-T6S.063)  
FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1

11

DOUBLER TO SIT ON TOP OF FOAM AT THIS LOCATION

12

DOUBLER TO BE RECESSED FLUSH INTO FOAM AT THIS LOCATION

13

RUBBER STAMP WITH DART P/N D3140-05/-06/-07/-08 USING MIL-STD-130

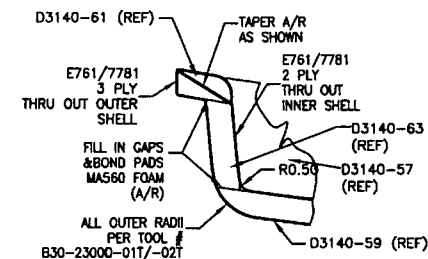
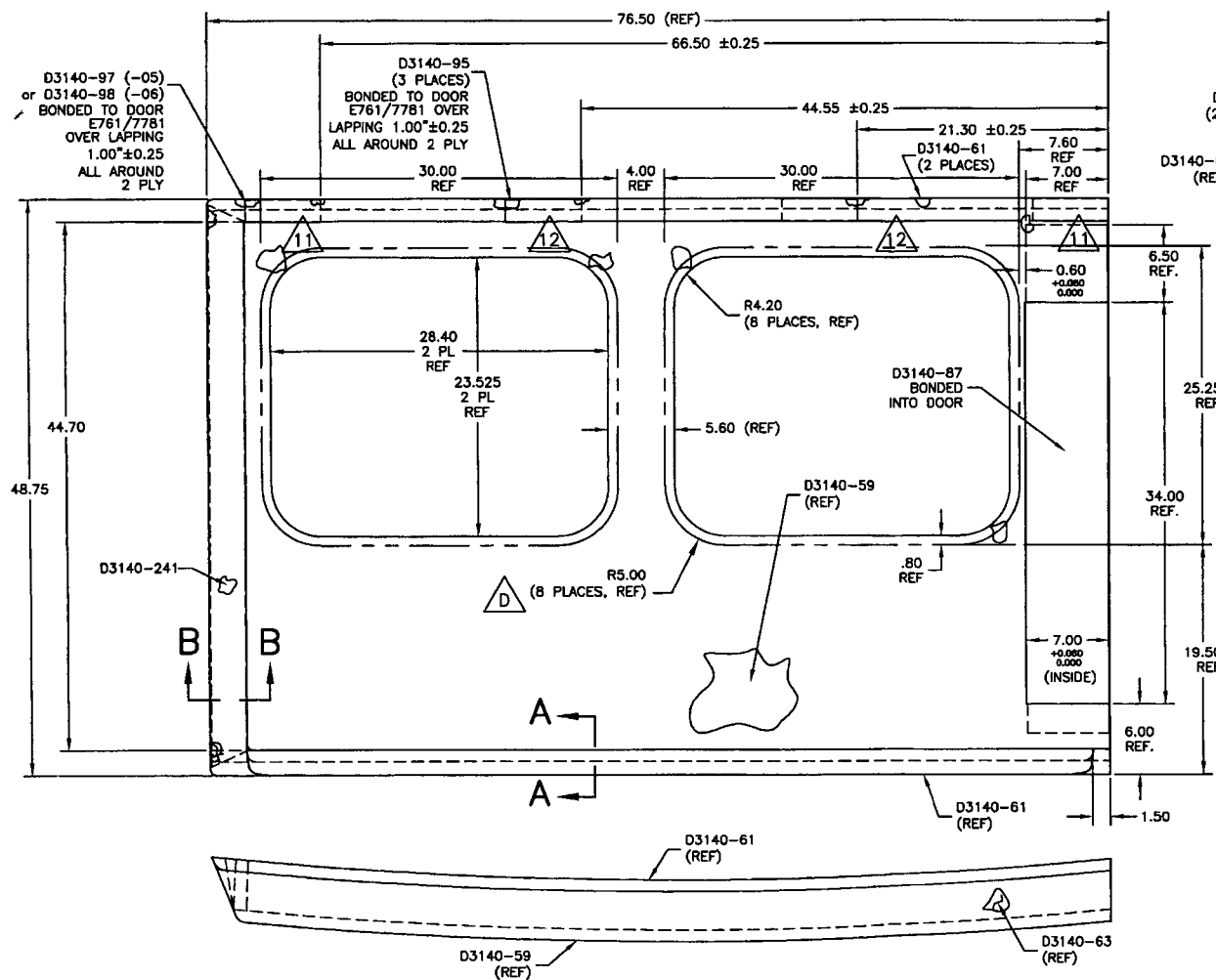
14

PARTS MUST BE SCUFFED WITH 80 GRIT SANDPAPER PRIOR TO ACID ETCH AND  
ALODINE PER DART QSI 005 4.1



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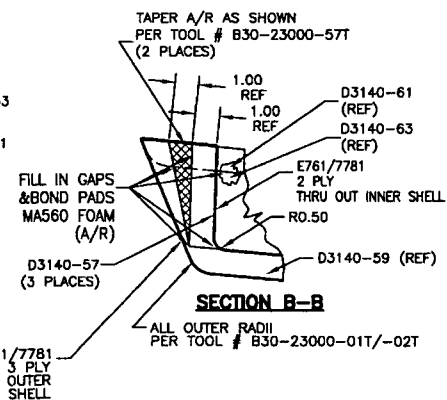
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SECTION A-A

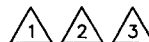
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SECTION B-B

**D3140-05 DOOR (SHOWN, REPLACES PREMIER P/N B30-23000-05)**  
**D3140-06 DOOR (OPPOSITE, REPLACES PREMIER P/N B30-23000-06)**  
(WINDOWS & CUTOUTS TO BE LOCATED PER B30-23000-01T/-02T TOOL)

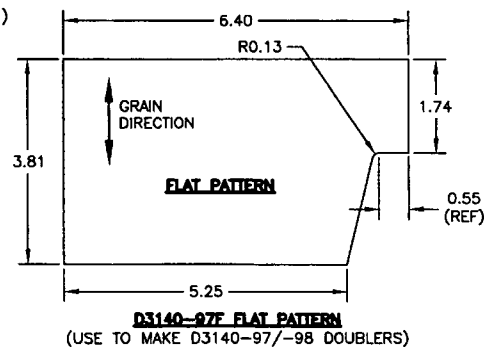
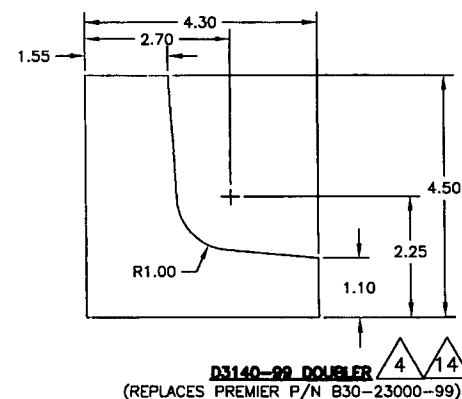
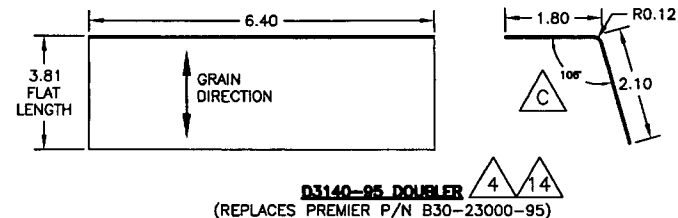
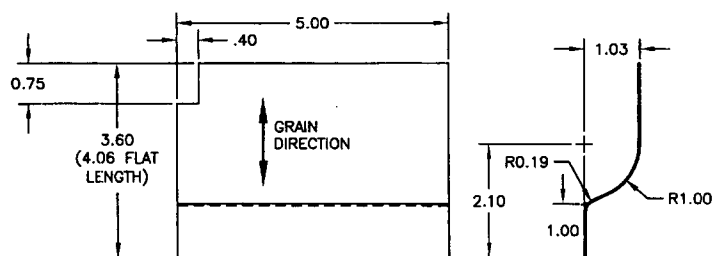
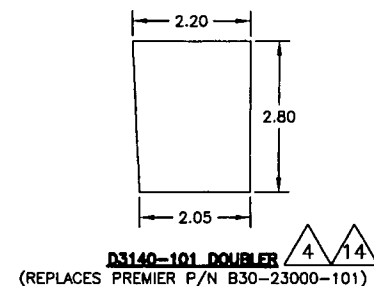
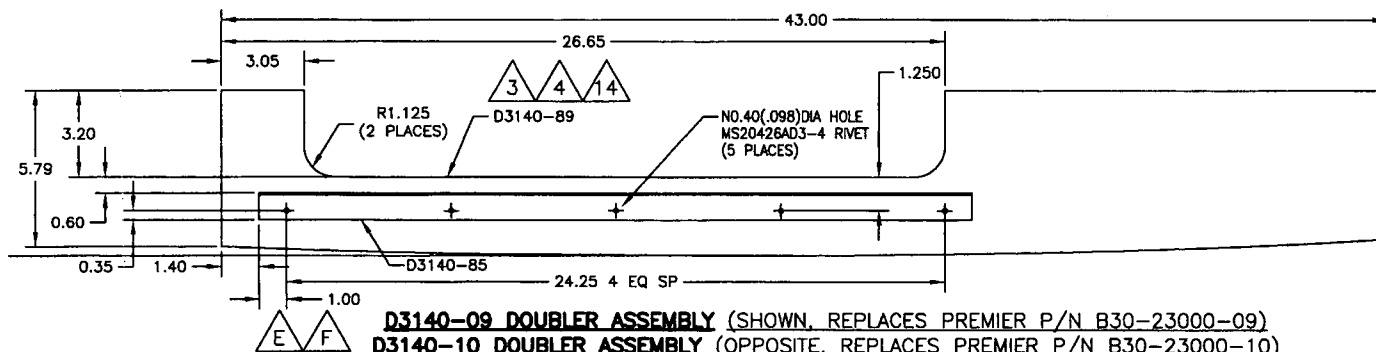


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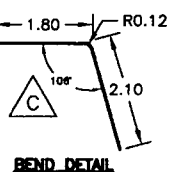
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DATE 06.10.06	TITLE DOOR	SCALE MTS	





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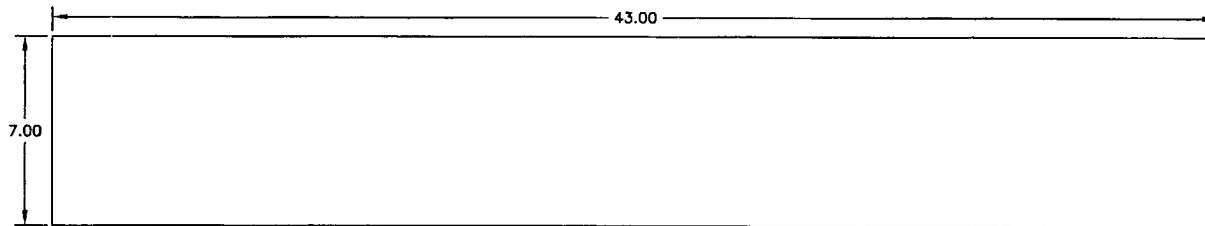
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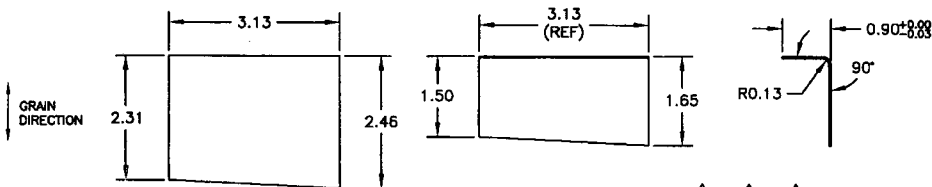
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DATE	06.10.06	D3140	SHEET 5 OF 7
		TITLE	SCALE
		DOOR	MTS

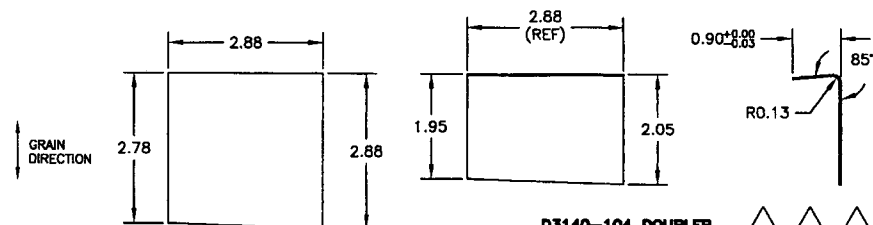


**D3140-87 DOUBLER**   
(REPLACES PREMIER P/N B30-23000-87)



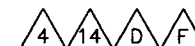
**D3140-105F FLAT PATTERN**  
(USED TO MAKE D3140-105/-106 BRACKETS)

**D3140-105 DOUBLER**  
D3140-106 OPPOSITE

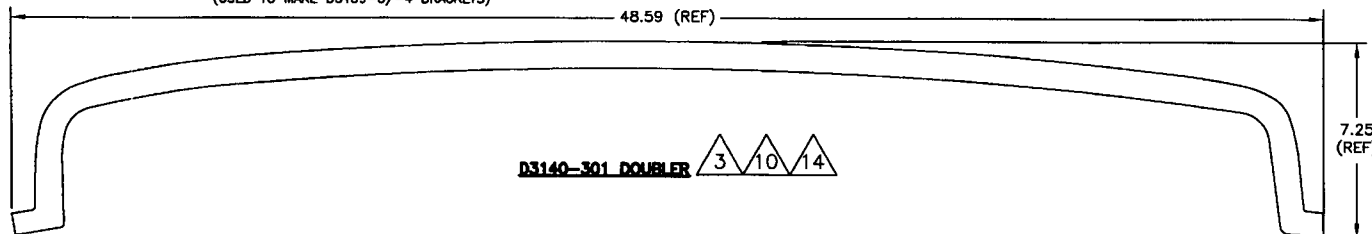


**D3140-103F FLAT PATTERN**  
(USED TO MAKE D3140-103/-104 BRACKETS)

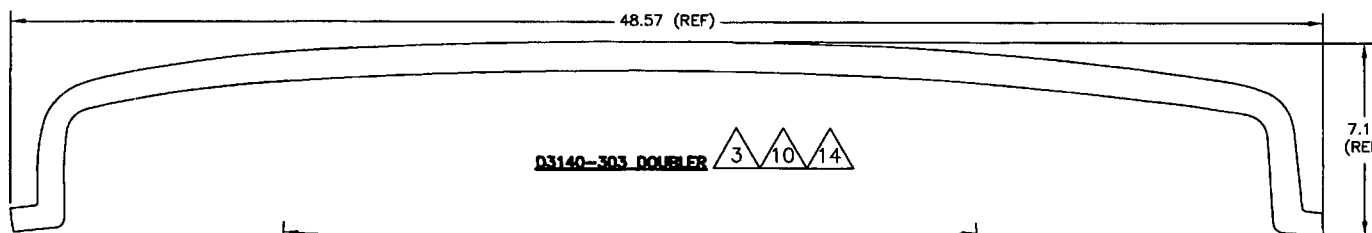
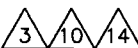
**D3140-104 DOUBLER**  
D3140-103 OPPOSITE



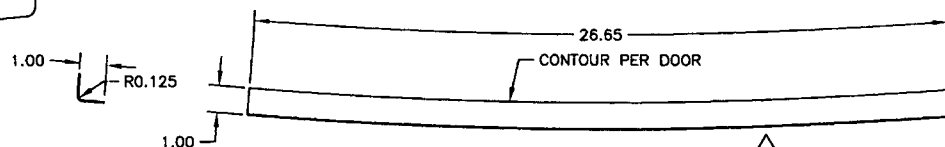
**D3159-3F FLAT PATTERN**  
(USED TO MAKE D3159-3/-4 BRACKETS)



**D3140-301 DOUBLER**



**D3140-303 DOUBLER**



**D3140-85 ANGLE**   
FLAT PATTERN: 26.65" x 1.90"  
(REPLACES PREMIER P/N B30-23000-85)

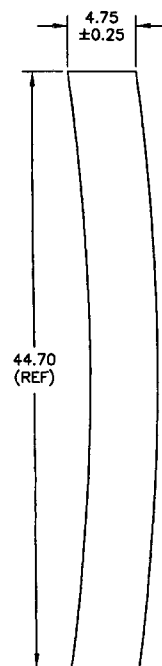
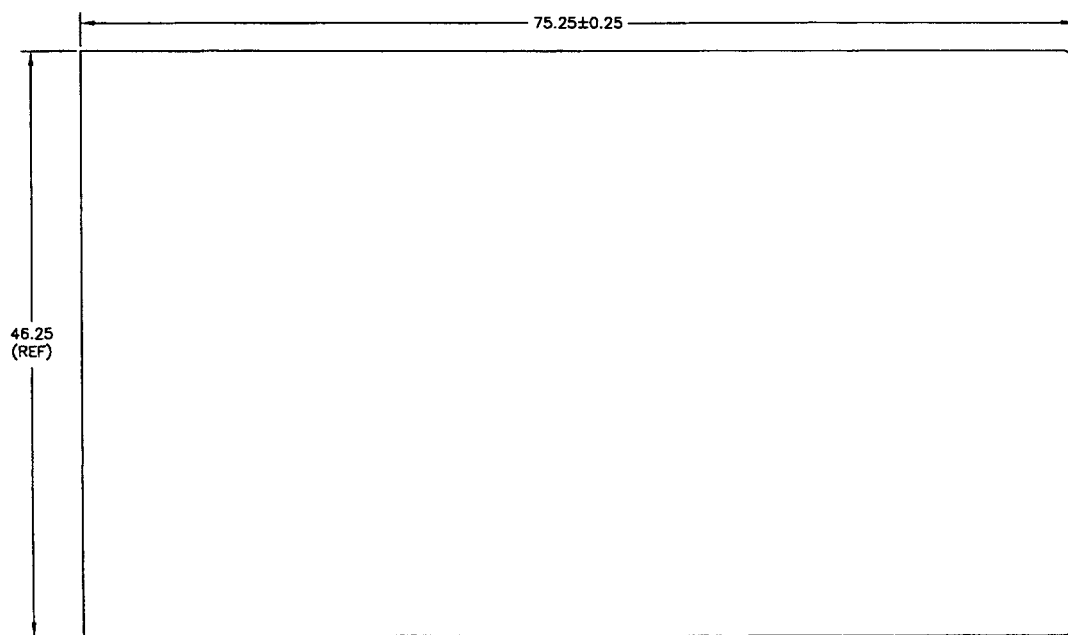
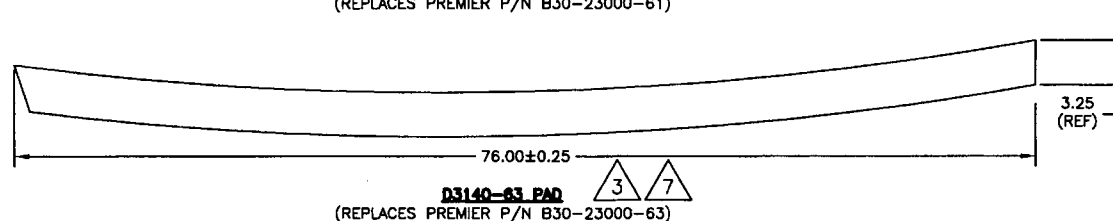
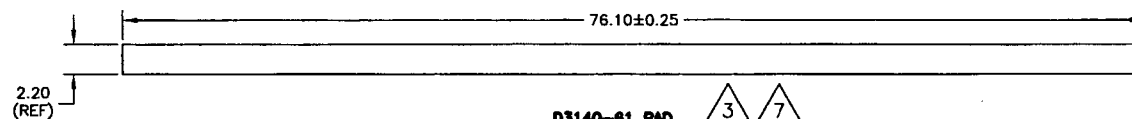
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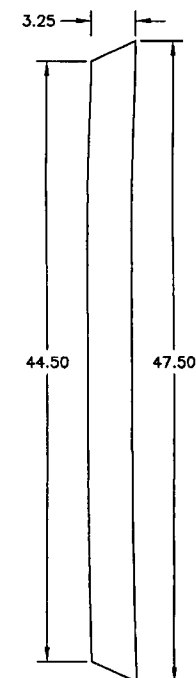
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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3140	REV. F SHEET 6 OF 7
DATE 06.10.06	TITLE DOOR	SCALE	NYS



**D3140-57 PAD**  
(REPLACES PREMIER  
P/N B30-23000-57)

3 7



**D3140-241 DOUBLER** 5 14  
(REPLACES PREMIER P/N B30-23000-241)

RELEASED  
06.11.13

R1.00  
(2 PLACES, REF)

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		DATE		DRAWING NO.	REV. F
		06.10.06		D3140	SHEET 7 OF 7
				TITLE	SCALE
				DOOR	NTS



Qty -01	Qty -02	Qty -03	Qty -04	Part Number	Description
X				D012-694-01	DOOR ASSEMBLY
	X			D012-694-02	DOOR ASSEMBLY
		X		D012-694-03	DOOR ASSEMBLY
			X	D012-694-04	DOOR ASSEMBLY
		1	1	D0110-1	ESCUTOEON
		1	1	D0110-3	HANDLE
1	1			D0110-5	HANDLE ASSEMBLY
		1	1	D0111-041	PLATE ASSEMBLY
		2	2	D0112-1	GUIDE
		1	1	D0113-1	SPRING
		1	1	D0114-1	PIVOT
1	1			D0115-1	BRACKET
		1	1	D0116-11-0180	SEAL
		1	1	D0116-6-0680	SEAL
1	1			D0116-7-0680	SEAL
1	1			D0116-9-0770	SEAL
		1		D0119-041	COVER ASSEMBLY
		1		D0119-042	COVER ASSEMBLY
		1		D0120-1	COVER
		1		D0120-2	COVER
		1		D0120-3	COVER
		1		D0120-4	COVER
3	3			D0121-041	BRACKET ASSEMBLY (ROLLER)
1				D0121-043	BRACKET ASSEMBLY (ROLLER)
		1		D0121-044	BRACKET ASSEMBLY (ROLLER)
1	1			D0122-1	LEVER
2	2			D0123-1	CAM
1	1			D0124-1	HOCK
1	1			D0124-2	HOCK
		1	1	D0125-1	LEVER
		1	1	D0125-3	LEVER
		1	1	D0125-5	LEVER
		1	1	D0125-7	LEVER
1	1			D0126-1	BRACKET (SLIDER)
1	1			D0126-3	BRACKET (SLIDER)
5	5			D0126-6	BRACKET (SLIDER)
1	1			D0127-1	SPACER
		1	1	D0128-1	SHIM
		2	2	D0129-1	LEVER
		2	2	D0130-1	CLEVIS BASE
		1	1	D0131-1	STOP
1				D0132-041	ROD WELDMENT
		1		D0132-042	ROD WELDMENT
		1		D0133-041	ROD WELDMENT
1				D0133-042	ROD WELDMENT
		1	1	D0134-1	ROD
		1	1	D0134-3	ROD
1	1			D0135-041	HANDLE WELDMENT
1	1			D0137-046	BRACKET ASSEMBLY
1				D0138-1	COVER
		1		D0138-2	COVER
1	1			D0139-1	GUARD
1				D0139-3	GUARD
		1		D0139-4	GUARD
1				D0140-05	DOOR
		1		D0140-06	DOOR
		1		D0140-07	DOOR
		1		D0140-08	DOOR
2	2			D0141-1	SPRING
		1	1	D0143-1	CLEVIS
		3	3	D0143-3	CLEVIS
		1		D0144-1	DOUBLER
1				D0144-3	DOUBLER
		1		D0144-105	DOUBLER
		1		D0144-107	DOUBLER
1				D0144-109	DOUBLER

Qty -01	Qty -02	Qty -03	Qty -04	Part Number	Description
1	1			D0144-111	DOUBLER
	1			D0144-115	DOUBLER
		1		D0144-117	DOUBLER
		1		D0144-121	DOUBLER
		1		D0144-119	DOUBLER
	1			D0144-123	DOUBLER
1	1			D0144-13	DOUBLER
		1		D0145-1	HINGE BRACKET
		1		D0145-2	HINGE BRACKET
		1		D0146-1	HINGE BRACKET
		1		D0146-2	HINGE BRACKET
		2	2	D0147-1	PIN
2	2			D0148-1	CLEVIS
		2	2	D0149-1	STRINGER PLATE
		2	2	D0150-1	GUIDE
1	1			D0151-041	DOUBLER ASSEMBLY
1				D0152-041	BRACKET ASSEMBLY
	1			D0152-042	BRACKET ASSEMBLY
		1	1	D0154-1	KEY
1	1			D0155-041	BRACKET ASSEMBLY
1	1			D0155-042	BRACKET ASSEMBLY
2	2			D0156-1	BRACKET
		2	2	D0157-1	SPACER
		3	3	D0159-041	BRACKET ASSEMBLY
		1		D0159-043	BRACKET ASSEMBLY
		1		D0159-044	BRACKET ASSEMBLY
10	10			D0162-041	BRACKET ASSEMBLY
1		1		D0162-043	BRACKET ASSEMBLY
1		1		D0162-044	BRACKET ASSEMBLY
1				D0163-041	COVER ASSEMBLY
	1			D0163-042	COVER ASSEMBLY
1				D0163-041	BRACKET ASSEMBLY (TROLLER)
	1			D0163-042	BRACKET ASSEMBLY (TROLLER)
1	1			D0303-1	HANDLE ASSEMBLY
2	2			D0308-1	DOUBLER
55	55	21	21	80-006-28	INSERT (OR SL2092-3-4)
10	10			AN625-10F6	SCREW
8	8	4	4	AN625-10F7	SCREW
		8	8	AN680D10	WASHER
18	18	4	4	AN680D10L	WASHER
13	13	32	32	AN680D10LL	WASHER
6	6			AN680D16L	WASHER
		4	4	AN680D8L	WASHER
6	6			AN680D8	WASHER
		2	2	AN680D8L	WASHER
		2	2	AN680D8LL	WASHER
		10	10	ASL4-632-80	INSERT
87	87	50	50	BSP45	RIVET
		12	12	FW10-032	WASHER
		6	6	FW10-032	WASHER
12	12			M7885-24	RIVET (OR Q3213-4-3)
		3	3	M7885-34	RIVET (OR Q3212-4-3)
		2	2	MS2092-1C11	PIN
		7	7	MS2092-2C15	PIN
2	2			MS2092-2C17	PIN
2	2	2	2	MS2092-2C9	PIN
2	2			MS2092-3C21	PIN
8	8			MS2092-3C21	RIVET
12	12			M7885/3-4	RIVET
8	8			MS2092-6AD4	RIVET

Qty -01	Qty -02	Qty -03	Qty -04	Part Number	Description
28	28			MS2092-6AD4	RIVET
		6	6	MS21042L08	NUT
6	6	2	2	MS21042L06	NUT
		5	5	MS21042L3	NUT
4	4			MS21042L4	NUT
4	4			MS21072L3	NUT PLATE
6	6	9	9	MS24665-151	COTTER PIN
4	4			MS24683-SZ71	SCREW
		2	2	MS24684-04	SCREW
4	4			MS24684-05	SCREW
6	6			MS24684-35	SCREW
18	18			MS24684-550	SCREW
		4	4	MS24684-555	SCREW
		2	2	MS24684-563	SCREW
		4	4	MS24684-590	SCREW
4	4			MS24684-598	SCREW
		2	2	MS25261-R6	CLAMP
2	2	2	2	MS27039-1-05	SCREW
14	14	12	12	MS27039-1-06	SCREW
13	13	6	6	MS27039-1-08	SCREW
		2	2	MS36205-231	SCREW
2	2			MS36275-238	SCREW
2	2			MS36649-354	NUT
		4	4	MS36950-305T	NUT
2	2			MS36950-3252	NUT
2	2	3	3	MS31869-7	WASHER
		4	4	NASH169-10L	WASHER
		14	14	NAS308-6-8P	SCREW
		15	15	NAS308-6-8P	WASHER
7	7			NAS308-6-8P	SPACER
6	6			NAS308-6-8P	SPACER
		2	2	NAS308-6-8P	SPACER

#### GENERAL NOTES

- FOR ADJUSTMENT OF LOCKING MECHANISM PRIOR TO DOOR ASSEMBLY, SET AT UNLATCH POSITION AND ADJUST SCREW INWARD UNTIL D0124-1/2 HOOK RESTS AGAINST CUTOFF SHOWN IN VIEW N.
- IF REQUIRED, NOTCH D0125-1 LEVER (REF) TO CLEAR THE D0130-1 CLEVIS BASE (REF. 2 PLACES) TO ALLOW FOR FULL TRAVEL OF THE LEVER.
- HOLES AND PARTS TO BE LOCATED PER DRILLING JGS. 830-23000-01; D0144-T1/T2-T3; D0170-3; D0162-041/T1 (FOR -01 DOOR ASSY); D0144-T7-T8-T9; D0170-3; D0162-041/T2 (FOR -02 DOOR ASSY); D0144-T4-T5-T6; D0119-041/T1; D0112-T1/T2 (FOR -03 DOOR ASSY); D0144-T10-T11-T12; D0119-042/T1; D0112-T1/T2 (FOR -04 DOOR ASSY).
- INSTALL INSERTS PER PART Q3 005. LOCATE TO MATCH HOLE PATTERN OF MATING PARTS.
- TOLERANCES ARE PER PART Q3 018 UNLESS OTHERWISE NOTED.
- ALL DIMENSIONS ARE IN INCHES.
- IDENTIFY D012-694-01-02-03-04 DOOR ASSEMBLIES USING D0129-1 DECALS.

C1	06.03.28	ADD OPTION M7885/3-4
C	05.11.23	ADD D0137-045, D0162-043/-044; REMOVE D0137-041; UPDATED NOTES
B	04.10.07	UPDATE DRAWING
A	02.05.21	NEW ISSUE
DESIGN	CP	DRAWN BY RF
CHECKED	#	APPROVED #
DATE	05.11.23	TITLE DOOR ASSEMBLY
		SCALE N75

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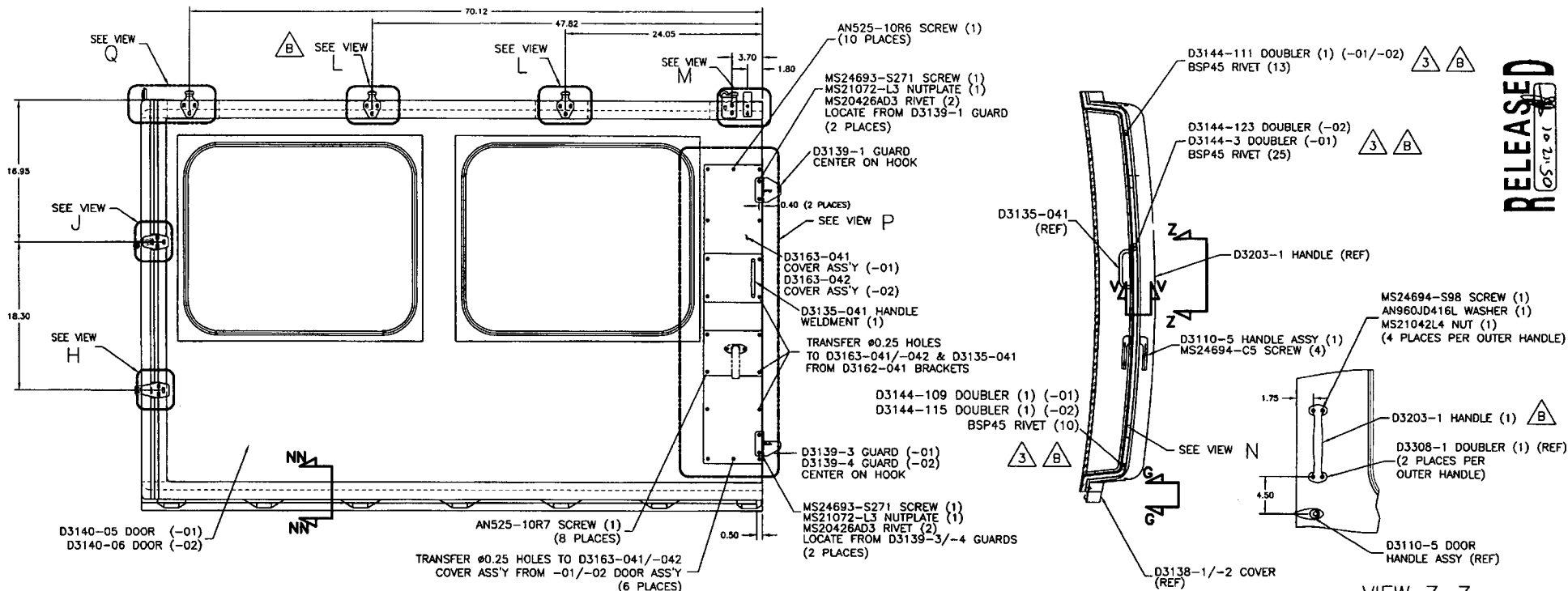
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DRAWING NO. D412-694  
SHEET 1 OF 6  
REV. C

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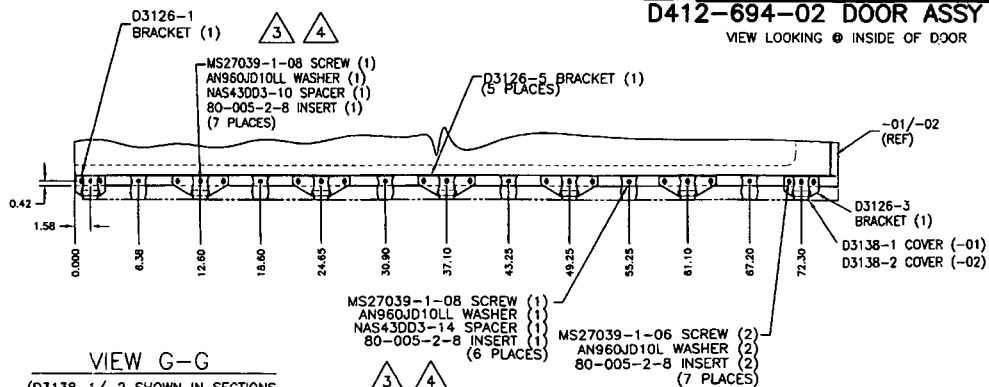


**D412-694-01 DOOR ASSY (SHOWN)**  
**D412-694-02 DOOR ASSY (OPP.)**

VIEW LOOKING @ INSIDE OF DOOR

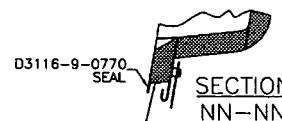
**VIEW Z-Z**

OUTER DOOR HANDLE INSTALLATION

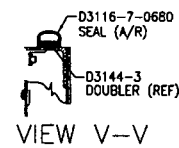
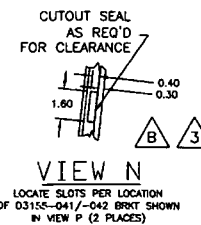


**VIEW G-G**

(D3138-1/-2 SHOWN IN SECTIONS FOR CLARITY OF HDWR LOCATIONS)

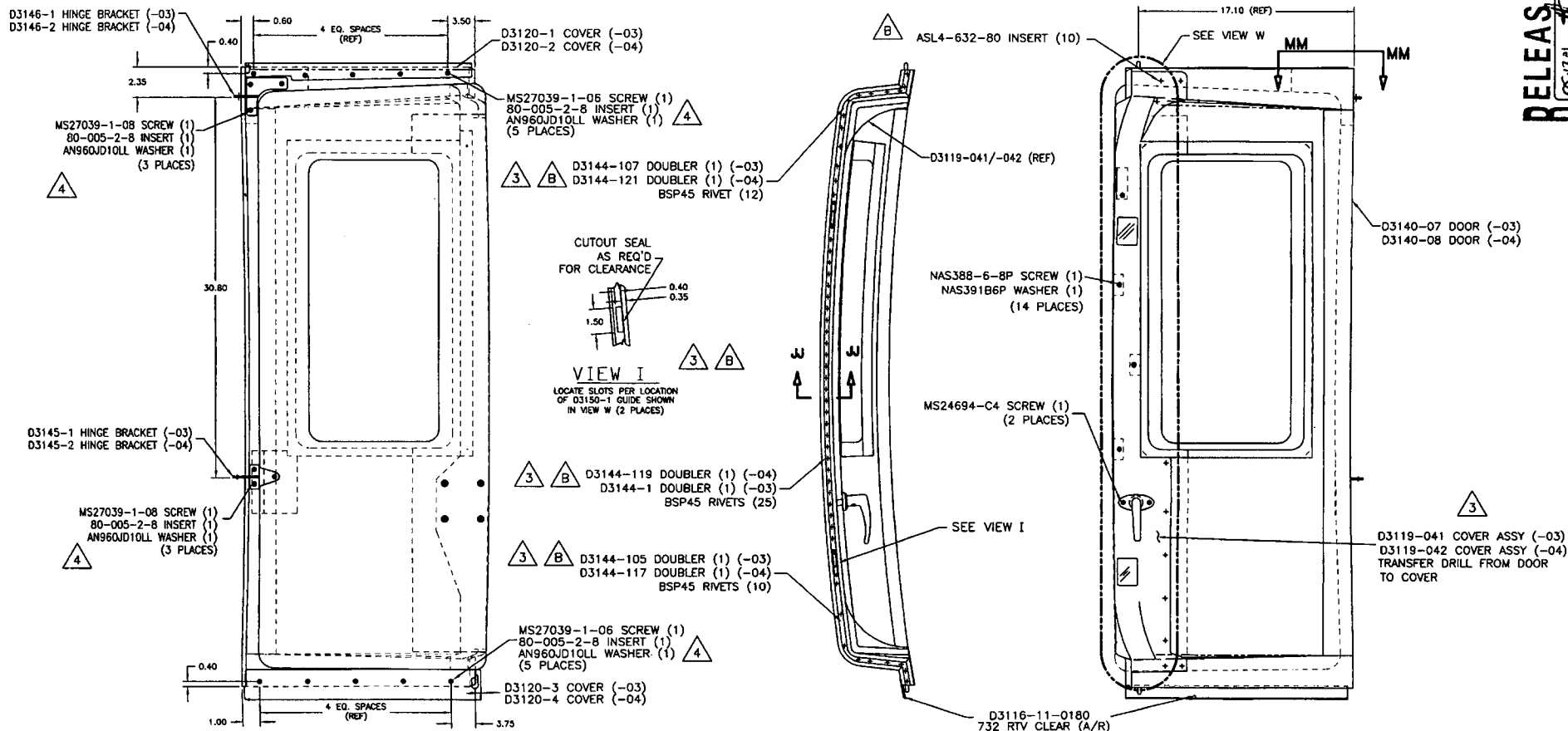


D3144-13 DOUBLER (1)  
 BSP45 RIVETS (39 PLACES)  
 TRANSFER DRILL #30 FROM DOUBLER TO DOOR  
 APPLY 732 RTV CLEAR (A/R) IN RIVET HOLE PRIOR TO INSTALLATION AND RIVET HEAD AFTER INSTALLATION



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DATE 05.11.23		TITLE DOOR ASSEMBLY		SCALE		SHEET 2 OF 6	
						NTS	

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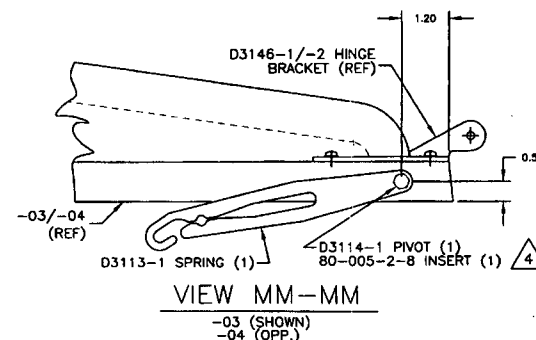
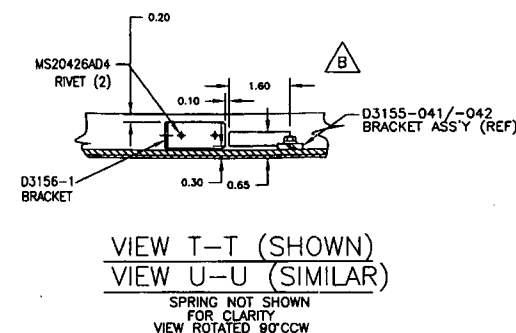
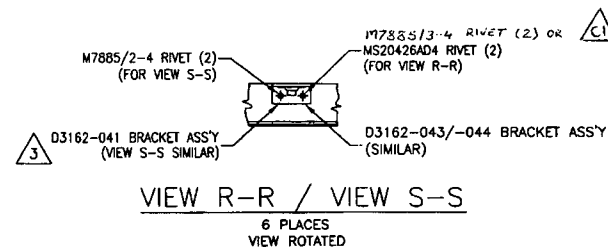
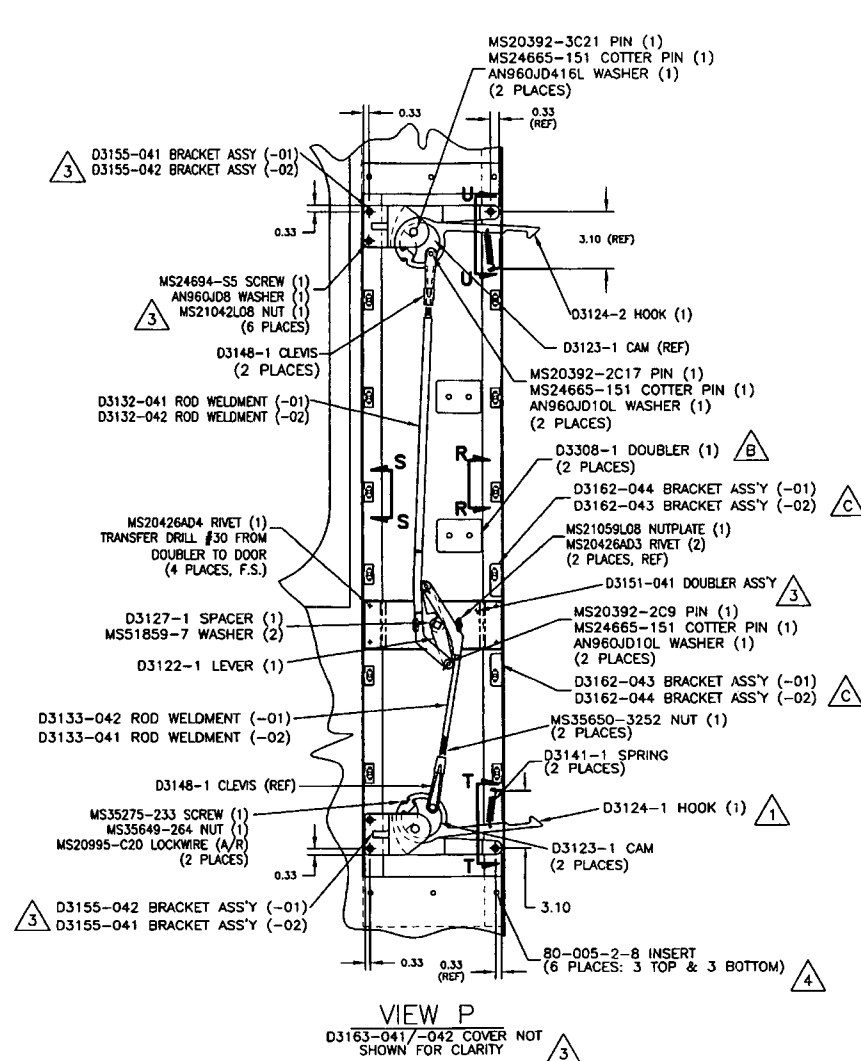


D412-694-03 DOOR ASSY (SHOWN)  
D412-694-04 DOOR ASSY (OPP)

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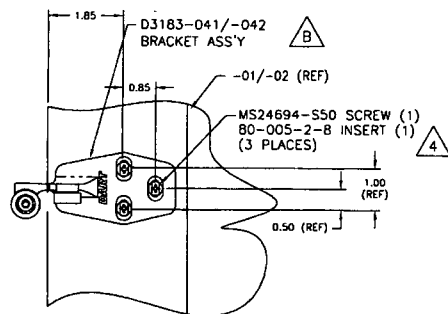


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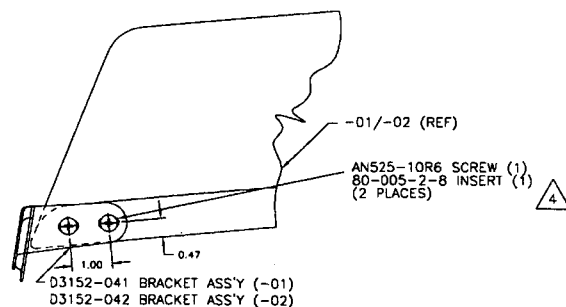
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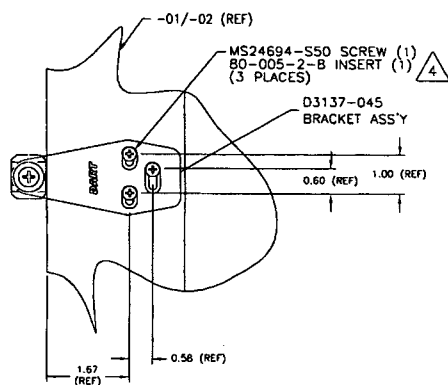
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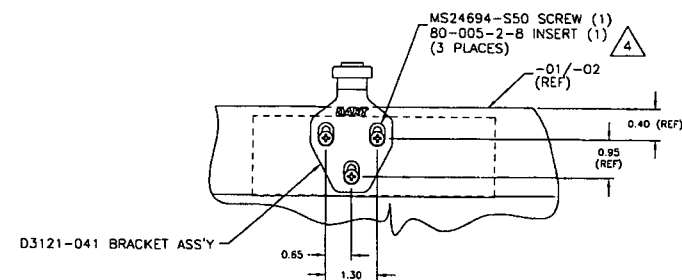
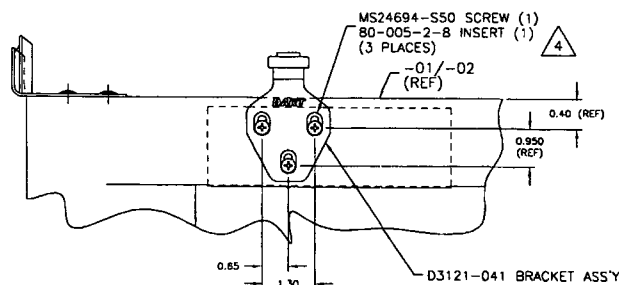
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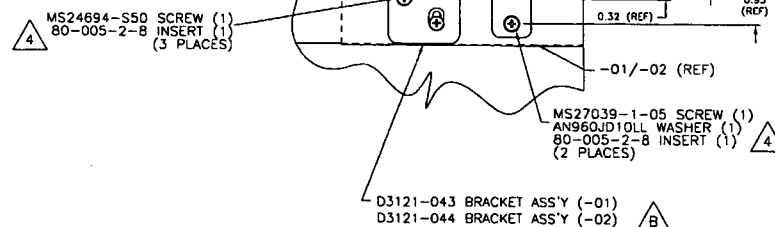
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VIEW H



VIEW L



VIEW M

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DESIGN  
CP

CHECKED  
#

DATE  
05.11.23

DRAWN BY  
RF

APPROVED  
#

**DART**

DART AEROSPACE LTD.  
MARKESBURY, ONTARIO, CANADA

DRAWING NO.  
D412-694

TITLE  
DOOR ASSEMBLY

REV. C  
SHEET 6 OF 6

SCALE  
NTS